

Work Order ID 86369

86369

Page 1

June-27-12 3:48:44 PM

Item ID: D2530

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Handle Weldment

Start Date: 27/06/2012 Start Qty: 10.00

10 15
10

Cust Item ID:

Required Date: 11/07/2012 Req'd Qty: 10.00

Customer:

Reference:

Run Start *NR1*

Stop *NR2*

Approvals: Process Plan: MLJ

Date: 12/06/28 Tooling:

Date:

QC:

Date: SPC (Y/N):

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2530	Rev B								
100		0.00							
100	Small Fab								
Small Fab	Memo	0.00							
Small Fab	1-Cut to length as per Dwg D2536 2-Deburr								
110	QC6- Inspect dimensions to drawing	0.00							
110									
QC	Memo	0.00							
Quality Control									
120	Weld per dwg A/R S.S. rod Batch: m/22357	0.00							
120	Small Fab								
Large Fab	Memo	0.00							
Large Fab	1-Weld as per Dwg D2530 and QSI 004 using Welding Jig DT8301								

(15) ml 13-03-26

(15) 13-03-26 DAS 09

(15) ml 13-03-27

Work Order ID 86369

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86369

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Item ID: D2530

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Handle Weldment

Start Date: 27/06/2012 Start Qty: 10.00

10

Cust Item ID:

Required Date: 11/07/2012 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds Memo	0.00 0.00				(15)	13-03-27		DAS 09 8-89
140 *140* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				(15)	13-03-27		DAS 09 8-89
150 *150* Powdercoat Powder Coating	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3 Memo START TIME: 3-20 OVEN TEMPERATURE: 320 °F FINISH TIME: 3-50	0.00 0.00							

15X X M- / 13/03/27

M123480

Work Order ID 86369

86369

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June-27-12 3:48:44 PM

Item ID: D2530

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Handle Weldment

Start Date: 27/06/2012 Start Qty: 10.00

10

Cust Item ID:

Required Date: 11/07/2012 Req'd Qty: 10.00

10

Customer:

Reference:

Run Start *NR1*

Stop *NR2*

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC3- Inspect Part Finish	0.00							
160						15	4	13-3-27	
QC	Memo	0.00							
Quality Control									
170	Identify as per dwg & Stock Location: <u>ST255</u>	0.00							
170						15x			
Packaging	Memo	0.00							<u>SP</u> 13-3-28
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							13/3/28
Quality Control									

MC5 13-03-28

Picklist Print

June-27-12 3:48:48 PM

Work Order ID: 86369

Parent Item: D2530

Parent Item Name: Handle Weldment

86369

D2530

Start Date: 27/06/2012

Required Date: 11/07/2012

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:E Removed Purchasing 05-11-07 JLM IPP Rev:F
11.01.07 chg qc 5 to 6 DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TR0.750W.049		Purchased	No			100	f	286.9558	2.9145	30.67895			

**

~~42.96875~~ 312 13-03-26

~~*M304TR0.750W.049*~~

304 RD Tube .750 x .049W

Location

Loc Qty

Loc Code

MAT017

286.955794

B124768 x 42.96875

109314

9.333

111619

3

112187

4

112800

11

114852

2.75

116108

3

117797

0.75

120441

0.000794

121170

234.89

121666

18.232

D2534

Manufactured No

120

Each

20.0000

2

20

**

~~130~~ 312 13-03-26

~~*D2534*~~

Lock Plate

Location

Loc Qty

Loc Code

WA

20

81878

20

B94177 x 10

B 92855 x 12

B 97737 x 8

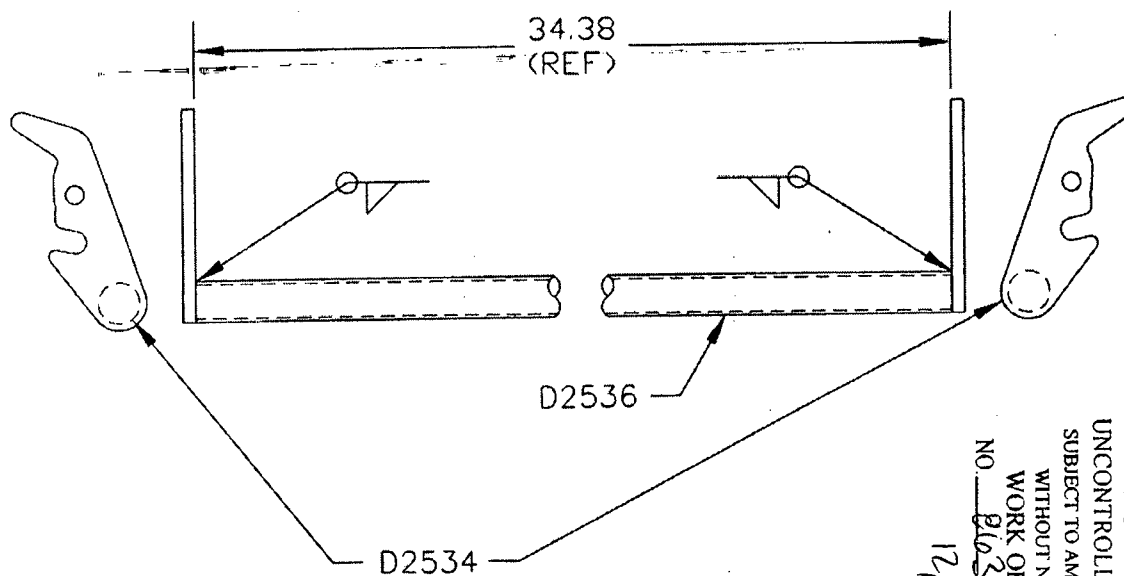


DESIGN	DRAWN BY	DART AEROSPACE LTD	
B WILLIAMS	PH	VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. B
		D2530	SHEET 1 OF 1
DATE		TITLE	SCALE
04.12.14		HANDLE WELDMENT	
A	96.06.18	NEW ISSUE	
B	04.12.14	UPDATE NOTES AND DIMENSIONS	

RELEASED
04.12.16

PART LIST -- D2530

QTY	PART NUMBER	DESCRIPTION
X	D2530	HANDLE WELDMENT
1	D2536	HANDLE
2	D2534	LOCK PLATE



D2530 HANDLE WELDMENT

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT BLACK (4.3.5.7) PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 86361 MLJ
12/06/28

Receiving Report

Date: B-2-28

Batch No: 124768

Supplier: marmom

Dart P/O: 19147

Packing Slip: Yes ☒ No ☐
 Invoice: Yes ☒ No ☐
 Receipt: Cash ☐ Cr ☒

Release Note Attached: Yes ☒ No ☐ N/A ☐
 Waybill Attached: Yes ☒ No ☐ N/A ☐
 Shipment Complete: Yes ☒ No ☐ N/A ☐
 QC6 Inspection DAS ☒ N/A ☒
 Work Order 16 ☒ N/A ☒

Discrepancies

Part Number	Description	Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	Comments

Initials of receiver (if shipment OK) Level 12

SP

Production/Admin: B-2-28

Date

Received/Costing

Initial

SP

Location _____

Thursday, February 28, 2013 8:13:01 AM

Page 1 of 1

All amounts are calculated in domestic currency.

All Vendors PO ID PO19147 Receipt Dates from 2/28/2013 to 2/28/2013 All Line Item Types
All Item ID/GL/WOs All Rec. Employees All Currencies
Grouped by Vendor ID

Purchase Order ID/ Carr Type	Line Nbr/ Insp Req	Project ID	Reference/ Description/ Cert Std	PO U/M / Stock U/M	Required Date Required Qty	Recv Date/ Recv Emp	Recv Qty (PO U/M)	Cost Per Unit/ Recv Value	Inspected Qty/ Rejected Qty (PO U/M)	MRB Qty/ MRB Reject Qty	Book Amt
VendorID/Vendor Name		VC-MAR001	Marmon/Keystone Canada Ltd.								
PO19147	1		M304TR0.750W.049 f		2/27/2013	2/28/2013	500.0000	\$1.91	0.0000	0	\$955.11
CAD	No		304 RD Tube .750 x f .049W 124768		500.0000	DESJ02		\$955.11	0.0000	0	
	2		M304TR0.375W.065 f		2/27/2013	2/28/2013	60.0000	\$1.26	0.0000	0	\$75.82
	No		304 RD Tube .375 x f .065W 124768		60.0000	DESJ02		\$75.82	0.0000	0	
	3		M6061T6T0.500W.0 f 58		2/27/2013	2/28/2013	300.0000	\$2.08	0.0000	0	\$623.03
	No		6061-T6 RD Tube f .500 x.058W 124768		300.0000	DESJ02		\$623.03	0.0000	0	
Total Received Quantity:											860.0000
Total Qty to Inspect (PO U/M):											0.0000
Total Reject Quantity:											0.0000
Total Receipt Value:											\$1,653.96
Total Balance Due Quantity:											0.0000



Marmon/Keystone Canada Inc.

ACIERS SPÉCIALISÉS

290 Chemin du Tremblay
Boucherville QU CAN J4B 5X9
TEL. 514/527-9153
FAX. 450/641-4357

PACKING SLIP

PAGE... 1
Order : 1129334
Date..: 02/25/2013

SOLD TO:

DART AEROSPACE LTD
1270 ABERDEEN STREET

HAWKESBURY ON CAN K6A 1K7

SHIPPED TO:

DART AEROSPACE LTD
1270 ABERDEEN STREET

HAWKESBURY ON CAN K6A 1K7

SHIP VIA		F.O.B.	SALESPERSON	YOUR ORDER NO.	
TST OVERLAND #222212		BOUCHERVILLE	C. Gee	PO19147	
Ordered	Description	Number Pieces	Quantity Shipped	Back Ordered	
01	Fax all papers to Linda Lacelle 613-632-1053 rev: 01/11 GD STAINLESS STEEL SEAMLESS TUBE SMLS TUBE 304L 3/4 X .049 A213 STS .750 .049 304L Tariff Number: 7304.41.99.90 Cust. part#: M304TR0.750W.049 HT# YX1107-515 ✓ HT# 3S095 ✓ Total... 500 /FT	7 18 25	140/FT 360/FT 500/FT		
02	STAINLESS STEEL SEAMLESS TUBE SMLS TUBE 304L 3/8 X .065 A213 STS .375 .065 304L Tariff Number: 7304.41.19.90 Cust. part#: M304TR0.375W.065 HT# YT13903 Total... 60 /FT	3 3	60/FT 60/FT		
03	ALUMINUM SMLS TUBE ATS .500 .058 D6061 Tariff Number: 7608.20.00.00 Cust. part#: M6061T6T0.500W.058 HT# F00015496 ✓ HT# F00013711 ✓ Total... 300 /FT	19 6 25	228/FT 72/FT 300/FT		

No. of Bdl's/Pieces

1 / 0

Total Weight.....:

226

Customers.: _____



A Marmon Distribution Services/Berkshire Hathaway Company

GAOLIN高林

湖州高林不锈钢管制造有限公司

HUZHOU GAOLIN STAINLESS STEEL TUBE MANUFACTURE CO.,LTD

Product Name: Seamless stainless steel tube

Contract No: MN3084

Customer: MARMON/KEYSTONE CANADA INC.

Spec.: ASTM 269/A213/A213M and the purchasing order's requirement

Special Equipment Manufacture License NO.TS2710F28-2011

Certificate No:QC12-8-28-2

Date of issue: 2012-08-28

MILL TEST REPORT

Item No.	Heat No.	Lot No.	Product Standard	Grade	Size IN O.D.×W.T.×Length	Chemical Composition										
						Elements	C	Mn	P	S	Si	Ni	Cr	Ti	Mo	N
						Required Values%	≤0.035 max	≤2.00 max	≤0.045 max	≤0.030 max	≤1.00 max	8.00~12.00	18.00~20.00			
4#	YX1107-515	A120809-13	ASTM A269/A213 ASME SA213 A.W. A1016 NACE MR0175 ASTM A302-B	304L	5/8"×0.065"×20'	Results	0.017	0.83	0.033	0.003	0.330	8.10	18.39			
5#	YX1107-515	A120808-16			3/4"×0.049"×20'		0.017	0.83	0.033	0.003	0.330	8.10	18.39			
6#	YX1107-515	A120808-17			1"×0.065"×20'		0.017	0.83	0.033	0.003	0.330	8.10	18.39			
Quantity				Surface & Dimension Inspection	Eddy Current Test	Ultrasonic Test	Intergranular Corrosion Test	Pneumatic Test	Flaring Test	Flattening Test	Austenitic	Granular Test				
Item No.	Weight (kg)	Piece	Total Length (feet)													
4#	1	50	1000	Acceptable	Acceptable	/	Acceptable	Acceptable	Acceptable	Acceptable	/	Acceptable				
5#	1	480	9600													
6#	1	105	2100													
Mechanical Properties		Yield Strength Mpa	Tensile Strength Mpa	% Elongation	HRB	<p>WE HEREBY CERTIFY THAT THE MATERIAL DESCRIBED HEREIN BE MADE IN ACCORDANCE WITH THE RESULTS OF THE CONTRACT AND COMPLY WITH THE SPECIFICATION ABOVE.</p> <p>THE CERTIFICATE SHALL NOT BE REPRODUCED EXCEPT IN THE WRITTEN APPROVAL(WAY OF GETTING APPROVAL:FAX WRITTEN REQUEST TO OUR COMPANY AND GET REFAX) OF THE WORKS.</p> <p>THE CERTIFICATE ACCORDING TO EN10204 DOCUMENT 3.1</p> <p>IF THERE IS ANY DOUBT ABOUT THE CERTIFICATE,WELCOME TO GIVING YOUR PRECIOUS OPINION TO US.</p> <p>BY TEL: 0572-3623588 OR FAX: 0572-3628879.</p>										
Item No.	Required values	≥170 min	≥485 min	≥35 min	<80											
4#	Results	295/305	590/600	53.5/52.0	83.5/64.5											
5#		315/320	600/610	53.0/51.5	64.0/65.5											
6#		300/310	595/605	54.0/51.0	61.5/62.5											
Delivery: Solution Annealed, Pickled, 320G Polished						<p>QC DEPARTMENT</p> <p>Judge: _____ Reporter: _____</p>										

Q.C. Reviewed
AS 10/24/12

2012/10/24 * MN3084 * 1005560 * C12-8-28-2



MILL INSPECTION CERTIFICATE



CHANGSHU WALSIN SPECIALTY STEEL CO.,LTD.
EN 10204 3.1

CUSTOMER: MARMON/KEYSTONE CANADA INC. 2012/7/30		HEAT NO.: 33095																	
COMMODITY: STAINLESS STEEL SEAMLESS TUBE		CONDITION: COLD FINISHED, ANNEALED, PICKLED, PLAIN END																	
		CERTIFICATE NO.: 201208038024002																	
		GRADE: TP 304L																	
CHEMICAL COMPOSITION (WT%)																			
ELEMENTS	C	Si	Mn	P	S	Ni	Cr	Mo	N	Cu	Ti	Co+Ta	Co	Al	V	B			
SPECIFICATION	min					8.000	18.000												
	max	0.035	1.000	2.000	0.045	0.030	12.000	20.000											
RESULTS (LADLE)		0.015	0.270	1.880	0.028	0.001	8.540	18.190											
RESULTS (PRODUCT)		0.011	0.296	1.960	0.024	0.002	8.204	18.130											
SIZE(mm)	PACKAGE NO.	PIECES	WEIGHT		TS MPa	YS 0.2% MPa 1% MPa		EL (50mm) %	HARDNESS HRB	FLATTENING TEST	FLARING TEST	I.C. TEST	GRAIN SIZE	Lot No.	HYDROSTATIC TEST	EDDY CURRENT TEST	ULTRASONIC TEST		
OD(") x WT(")			FT	(kg)															
0.750*0.049	20-1#	150	3000	512	585/575	285/300		57/56	77-578.5	GOOD	GOOD	GOOD		201206-GL-017		GOOD	GOOD		
TOTAL:			150	3000	512														
REMARK: AS PER ASTM A213-11, ASME SA213-10/ASTM A269-10 ASTM A1016 NACE MR 0175 PO MN2441 LENGTH 20FT IC TEST PER ASTM A262, PRACTICE E MATERIAL FREE FROM MERCURY CONTAMINATION NO REPAIR BY WELDING MADE IN CHINA HRB MAX 80 400#POLISHED					1. WE HEREBY CERTIFY THAT THE MATERIAL DESCRIBED HEREIN BEEN MADE IN ACCORDANCE WITH THE RESULTS OF THE CONTRACT, AND CONFORM TO THE SPECIFICATION ABOVE. 2. THE CERTIFICATE SHALL NOT BE REPRODUCED EXCEPT IN FULL WITHOUT THE WRITTEN APPROVAL OF THE COMPANY. <div style="text-align: center;"> SUN BIN QUALITY MANAGER</div>														

ADDRESS: 56# RENMIN ROAD, HAIYU TOWN, CHANGSHU CITY, JIANGSU PROVINCE, CHINA 215519 TEL: +86-512-52566260 FAX: +86-512-52568027
WLCS-QP-T24-06

Q.C. Reviewed
SR 09/18/12



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO19147

Purchase Order Date 2/21/13

PO Print Date 2/21/13

Page Number 1 of 2

Order From :

MARMON/KEYSTONE CANADA LTD.
290 CHEMIN DU TREMBLAY
BOUCHERVILLE, QC J4B 5X9
CA

VC-MAR001

Contact Name

Vendor Phone 800 361 8142

Vendor Fax 450 641 4357

Vendor Account Nbr

Buyer

Chantal Lavoie

Requisition Nbr

Tax Resale Nbr

10127-2607

Terms

Net 30

Currency

CAD

FOB

Destination-Collect

Ship To :

DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

FAXED
2/21/13

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	M304TR0.750W.049	304 RD Tube .750 x .049W	2/27/13 Yes	500.00 f	TST ground	\$1.9500	\$975.00
		Special Inst:	MATERIAL: AISI 304/316 SS SEAMLESS ROUND TUBING AS PER ASTM A213 OR ASME SA213 OR ASTM A269				
2	M304TR0.375W.065	304 RD Tube .375 x .065W	2/27/13 Yes	60.00 f	TST ground	\$1.2900	\$77.40
		Special Inst:	MATERIAL: AISI 304/316 SS SEAMLESS ROUND TUBING AS PER ASTM A213 OR ASME SA213 OR ASTM A269				
3	M6061T6T0.500W.058	6061-T6 RD Tube .500 x.058W	2/27/13 Yes	300.00 f	TST ground	\$2.1200	\$636.00

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required - YES NO

Change Nbr: 1

Change Date: 2/21/13



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO19147

Purchase Order Date 2/21/13

PO Print Date 2/21/13

Page Number 2 of 2

Order From :

VC-MAR001

MARMON/KEYSTONE CANADA LTD.
290 CHEMIN DU TREMBLAY
BOUCHERVILLE, QC J4B 5X9
CA

Contact Name

Vendor Phone 800 361 8142

Vendor Fax 450 641 4357

Vendor Account Nbr

Buyer

Chantal Lavoie

Requisition Nbr

Tax Resale Nbr 10127-2607

Terms Net 30

Currency CAD

FOB Destination-Collect

Special List:

MATERIAL: 6061-T6 OR 6061-T62
TUBING PER
WW-T-700/6 OR AMS 4080 OR AMS 4082
OR
QQ-A-200/8 OR QQ-A-225/8

PO Total:

\$1,688.40

MATERIAL CERTIFICATION
REQ'D UPON DELIVERY

Change Nbr: 1

Change Date: 2/21/13

No substitution or deviation without
consent.

Certificate of Conformity or Material
Certification required ☒ YES ☐ NO